

**Work Order ID 110153**

December-17-13 9:16:36 AM

**\*110153\***

Page 1

Item ID: D3913-041

Revision ID:

Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13 Start Qty: 1.00

Required Date: 12/17/13 Req'd Qty: 1.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 13-12-18

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3913

C

D4020

A

100

Weld per dwg A/R S.S. rod Batch: 124816 0.00

Large Fab

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A  
\*\*\*inspect before welding mesh\*\*\*2- Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913  
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends3- weld hinge (3) and Mounting brackets as per dwg D3913  
\*\*\*take lid to locate hinge and bracket\*\*\*

4- Weld D4672-1 blanking plates as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Quality Control

Memo

0.00

1  
QC 14.3.1414.03.14DAS  
9  
9-89



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Item ID: D3913-041

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Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

① 14-03-14

DAS  
9  
9-89

125

Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

Memo

0.00

Hand Finishing

1 7B/14-3-20



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**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

Powder Coating

Memo *M128007.*

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: *9:00*OVEN TEMPERATURE: *400°*FINISH TIME: *9:30*

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

0.00

*1 0 14-3-20.*

DAS 34 9.89

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Quality Control

Memo

0.00

*1x f ll 1/03/20*



**Work Order ID 110153**

December-17-13 9:16:36 AM

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Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Assemble as per dwg

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: w/o

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

DAS

27

9-89

14/3/20

D4030-041/13109474

1x 1 14/03/20

1

1x 1 14/03/20

**Work Order ID 110153**

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**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center ID

180

**\*180\***

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

14-03-20

14-03-21





# Picklist Print

December-17-13 9:16:35 AM

Page 1

Work Order ID: 110153  
 Parent Item: D3913-041  
 Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13 Required Date: 12/17/13  
 Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP  
 REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total	Qty Issued	Date Issued	Status
D3913-1 Rib		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		3							
				103617		1							
				103755		2							
D3913-3 Rib		Manufactured	No			100	Each	0.0000	1	1			
D3913-7 Rib		Manufactured	No			100	Each	3.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		3							
				94828		3							
D3913-9 Hinge Rib		Manufactured	No			100	Each	0.0000	1	1			
D3916-5 Light Rib		Manufactured	No			100	Each	9.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		9							
				107317		8							
				107318		1							
D3916-041 Rib Assembly		Manufactured	No			100	Each	6.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		6							
				106740		4							
				107999		2							

DAS  
24  
9.00

B111030 → ①

DAS  
24  
9.00

B110253 → B110253 ①

DAS  
24  
9.00

B110302 → ②

DAS  
24  
9.00

B103728 → ①

DAS  
24  
9.00

B111013 → ③

DAS  
24  
9.00

B110945 → ②



# Picklist Print

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Work Order ID: 110153

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D4017-7  
Rib

Manufactured No

100 Each 20.0000

3 ~~DAS~~  
24  
9-83 3

Location

Loc Qty

Loc Code

WA004

20

106799

2

107296

18

3107295 → (3)

D4017-9

Rib

Manufactured No

100 Each 4.0000

2 ~~DAS~~  
24  
9-83 2

Location

Loc Qty

Loc Code

WA004

4

107394

4

3111084 → (2)

D4034-041

Aft Upper Rib Assembly

Manufactured No

100 Each 5.0000

1 ~~DAS~~  
24  
9-83 1

Location

Loc Qty

Loc Code

WA004

5

106006

1

106357

4

3110890 → (1)

D4034-043

Fwd Upper Rib Assembly

Manufactured No

100 Each 5.0000

1 ~~DAS~~  
24  
9-83 1

Location

Loc Qty

Loc Code

WA001

4

106655

4

WA004

1

105994

1

3111438 → (1)

D2581

Mounting Bracket

Manufactured No

100 Each 264.0000

2 ~~DAS~~  
24  
9-83 2

Location

Loc Qty

Loc Code

WA004

264

102265

94

103683

98

105886

48

107768

24

3103683 → (2)

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# Picklist Print

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Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

DAS  
26  
9-89

D2931 Manufactured No  
Bumper

150 Each 2,080.0000 2 2

Location

Loc Qty

Loc Code

GA

82

46064

82

ST021

1998

86435

1998

D3913-15 Manufactured No  
Wide Handle Plate

100 Each 30.0000 1 1

Location

Loc Qty

Loc Code

WA004

30

102500

4

102934

4

103568

8

107769

14

D4016-1 Manufactured No  
Hinge Half, Base

100 Each 48.0000 3 3

Location

Loc Qty

Loc Code

WA004

48

104200

20

106646

20

107938

8

D4021-1 Manufactured No  
Handle Plate

100 Each 35.0000 3 3

Location

Loc Qty

Loc Code

WA004

35

103509

7

107253

12

107621

8

108008

8

DAS  
24  
9-89

3102500 → ①

DAS  
24  
9-89

3106646 → ③

DAS  
24  
9-89

3112679 → ③

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# Picklist Print

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Work Order ID: 110153

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

DAS  
26  
9-89

D4021-5 Manufactured No  
Blanking Plate

100 Each 18.0000 2

② B113012

Location

Loc Qty

Loc Code

ST083

18

103829

6

107129

3

107549

8

85065

1

~~B113237~~ → ⑤

D4020-11 Manufactured No  
End Mesh, Basket

100 Each 16.0000 2

DAS  
24  
2-89

Location

Loc Qty

Loc Code

WA004

16

100330

16

B100614 → ②

D4672-1 Manufactured No  
Blanking Plate

100 Each 19.0000 2

DAS  
24  
1-89

Location

Loc Qty

Loc Code

WA004

19

100820

8

107975

11

B113239 → ②

M304EX0.75-16F Purchased No  
Expanded Metal Flat SS

100 sf 1,316.2736 33

DAS  
24  
1-89

Location

Loc Qty

Loc Code

WA004

1316.273598

M126052

39.4435977

M126500

73.83

M126899

99

M127024

640

M127403

464

M128080 → 33

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,287.0000

2

2

Cherry Rivets

DAS  
26  
9-89

## Location

## Loc Qty

## Loc Code

ST311

1154

112794

40

122151

4

122452

4

123525

282

124231

91

m127476

733

WA003

133

107939

133

MS21042L3

Purchased

No

150

Each

6,342.0000

6

6

Nut

14-3-20

DAS  
26  
9-89

## Location

## Loc Qty

## Loc Code

GA

194

M126333

194

ST314

28

M126036

28

ST506

793

123900

793

ST509

4000

M127304

1000

M127410

3000

ST510a

1327

M126275

8

M126333

1319

Lex

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# Picklist Print

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Work Order ID: 110153

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P Purchased No

150 Each 5,834.0000 12 12

DAS  
26  
9-89

Washer

Location

Loc Qty

Loc Code

GA 182  
122063 182  
ST294 158  
122063 158  
ST295 494  
123352 3  
123900 491  
ST510a 5000  
125646 5000

AN3-10A Purchased No

150 Each 187.0000

DAS  
26  
9-89

Bolt

Location

Loc Qty

Loc Code

ST351 4  
124221 3  
124858 1  
ST513 183  
m125709 183

NAS1149DN832J Purchased No

150 Each 2,507.0000

DAS  
26  
9-89

Washer

Location

Loc Qty

Loc Code

ST293 20  
M126221 20  
st510 398  
124555 398  
ST510a 2089  
M126319 1089  
M127255 1000

12x  
⑥ m128403

② m127813  
14-3-20

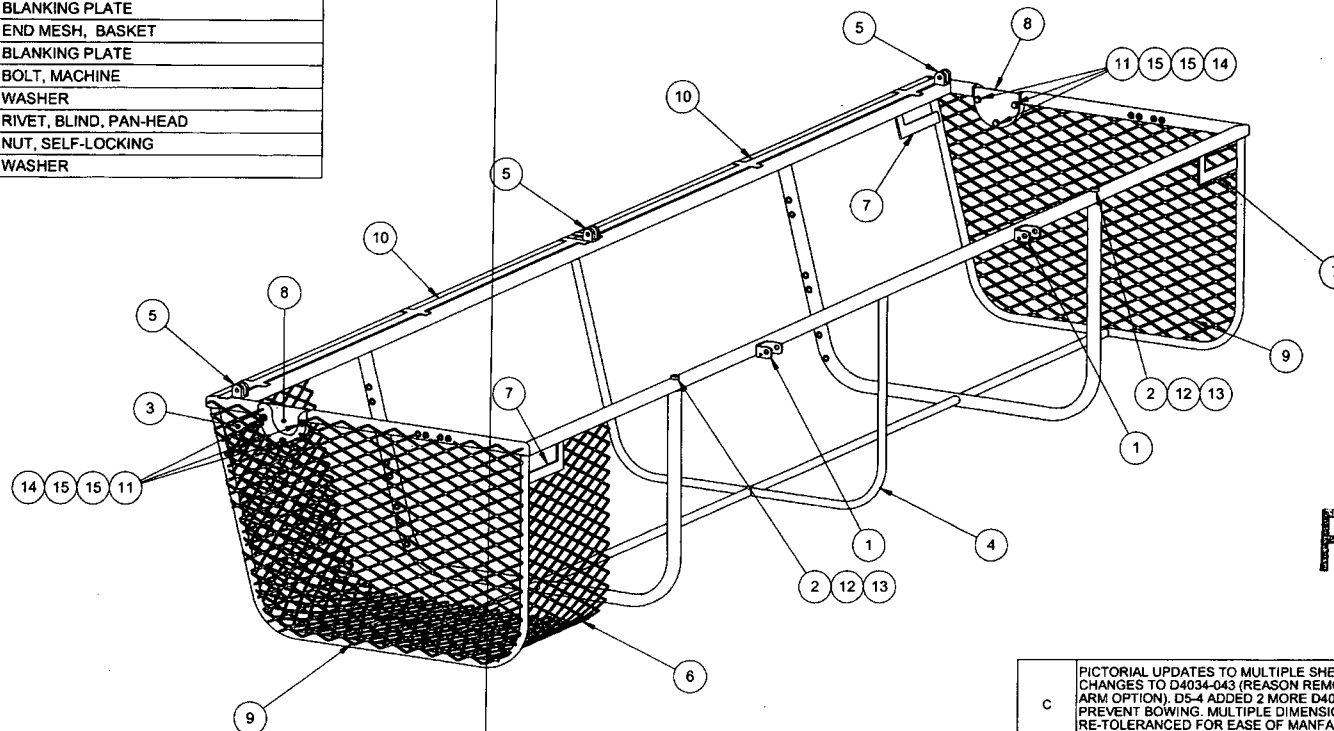
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Shop Packet Print

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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	3	D4021-1	HANDLE PLATE
8	2	D4021-5	BLANKING PLATE
9	2	D4020-11	END MESH, BASKET
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT, MACHINE
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET, BLIND, PAN-HEAD
14	6	MS21042L3	NUT, SELF-LOCKING
15	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

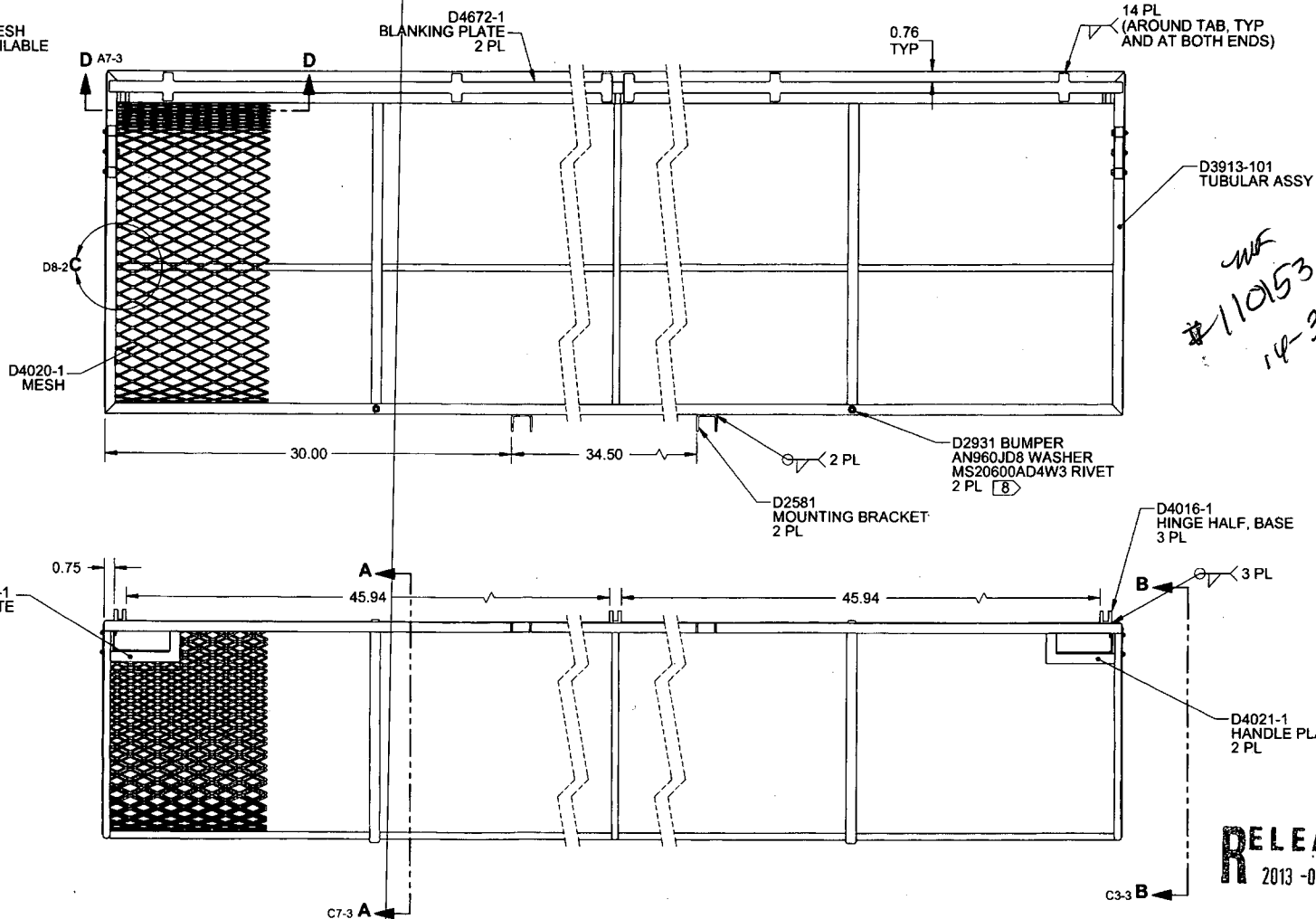
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2013-08-16  
M

C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION), D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.		AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-187.		MB	12.06.15
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS			
CHECKED	JP		DRAWING NO.	REV. C
MFG. APPR.	JP		D3913	SHEET 1 OF 6
APPROVED	JP		TITLE	SCALE
DE APPR.	JP		LONG BASKET BASE ASSY (350)	NTS
DATE	13.07.18		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

**DETAIL C** D7-2  
SCALE: 2X



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED	130718	TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

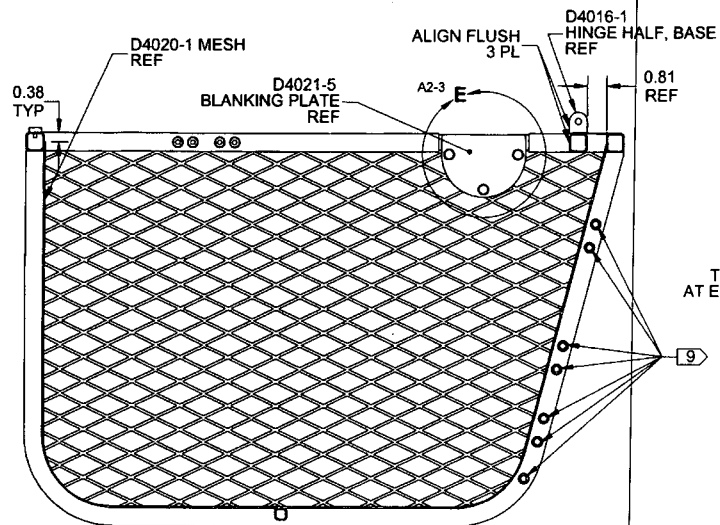
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

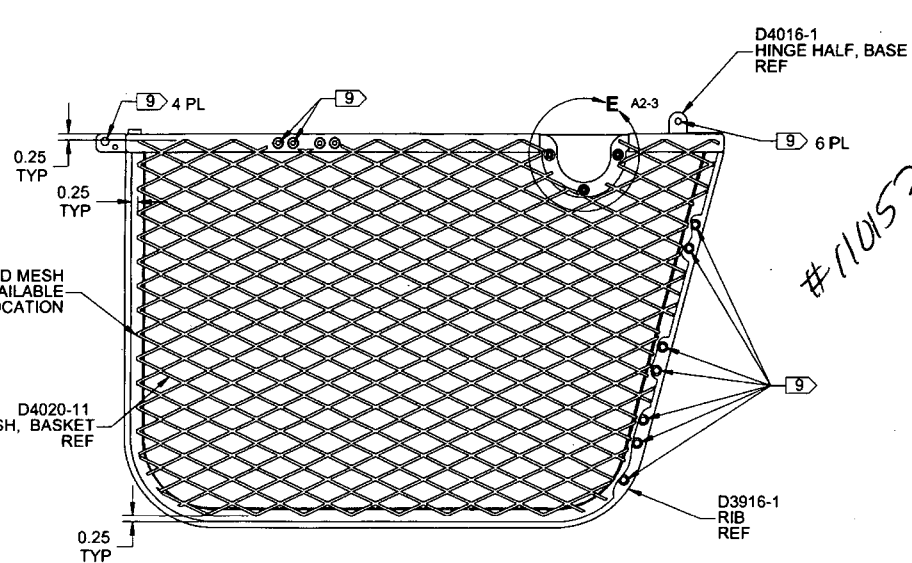
### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

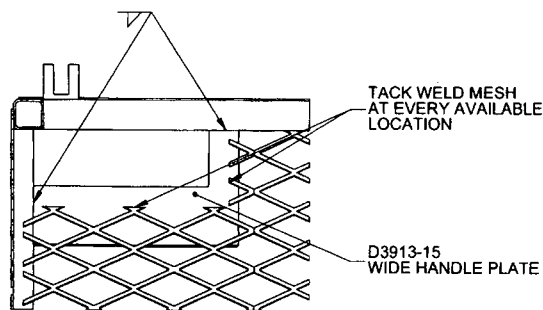




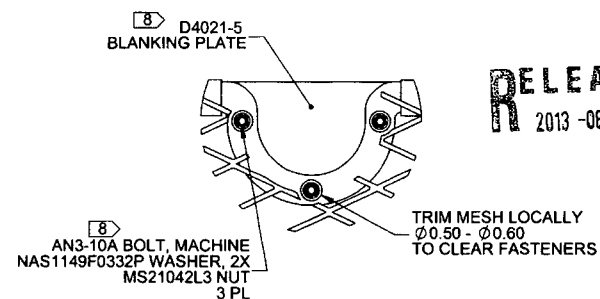
**SECTION A-A** A5-2



**VIEW B-B** A2-2







**SECTION D-D** D6-2  
TYPICAL FOR ALL  
HANDLE PLATES



**DETAIL E** D2-3  
D6-3

**RELEASED**  
2013-08-16  
AND

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

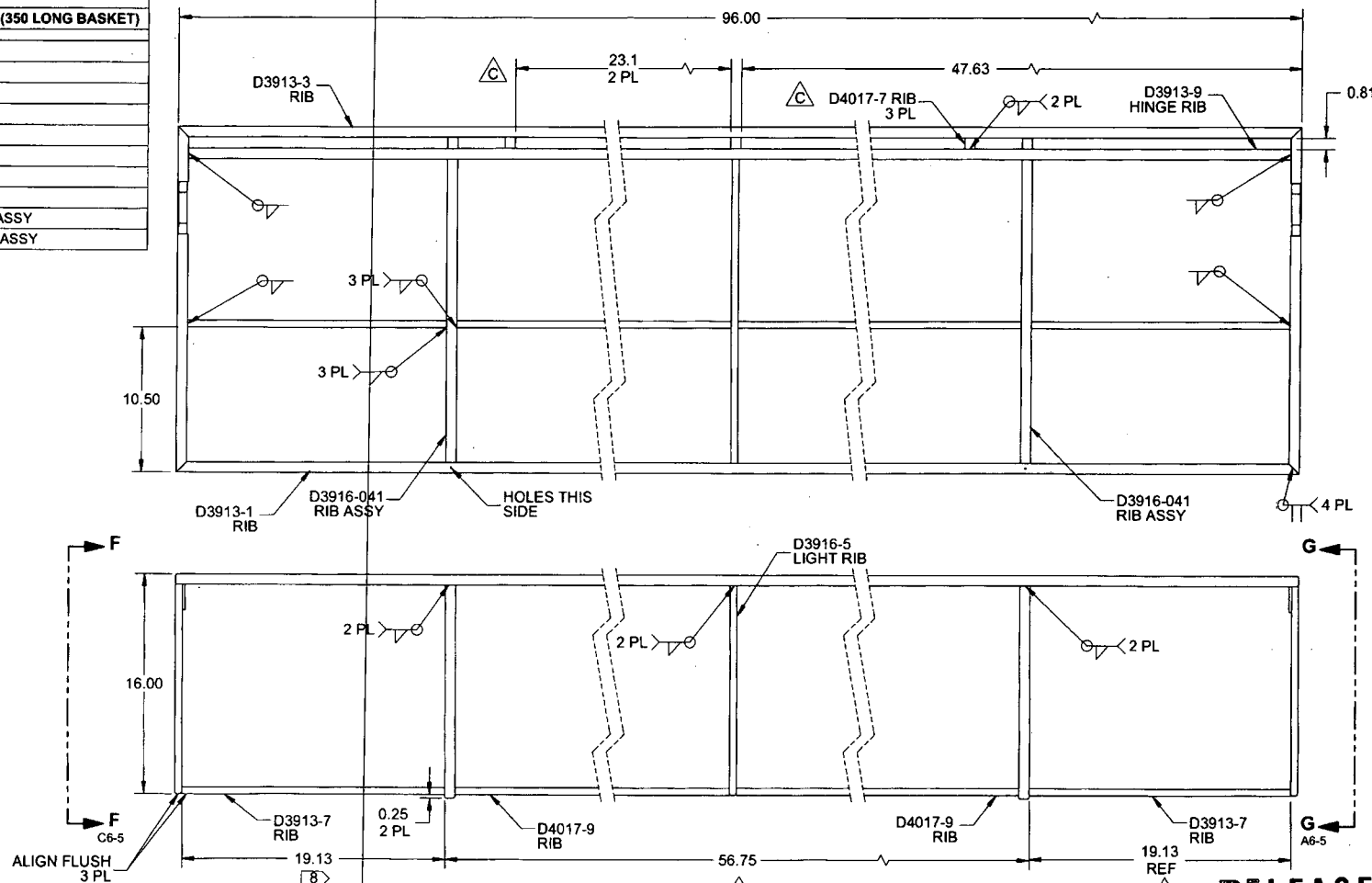
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	3	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



**D3913-101 TUBULAR ASSY (350 SHORT BASKET)**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 22.65 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
  - 9) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3913</b>	REV. C
MFG. APPR.	<i>[Signature]</i>	TITLE <b>LONG BASKET BASE ASSY (350)</b>	SHEET 4 OF 6 SCALE NTS
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>[Signature]</i>		
DATE	13.07.18		

**RELEASED**  
2013-08-16

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

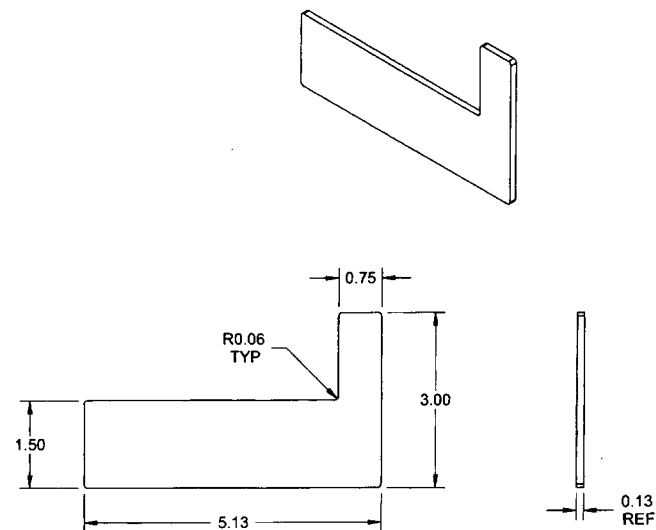
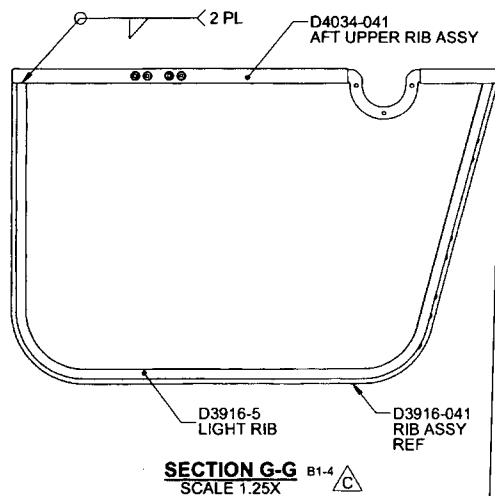
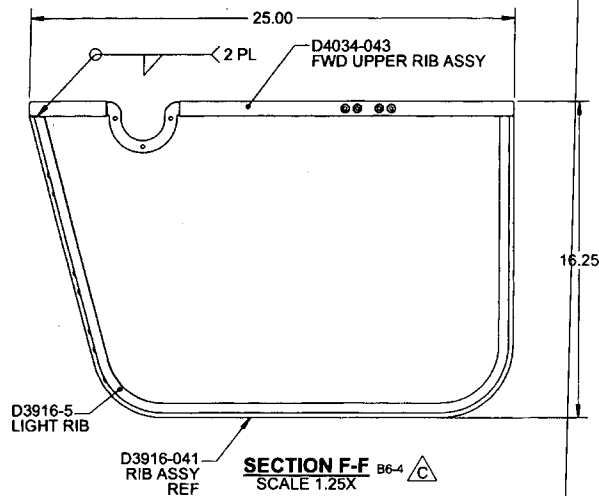
Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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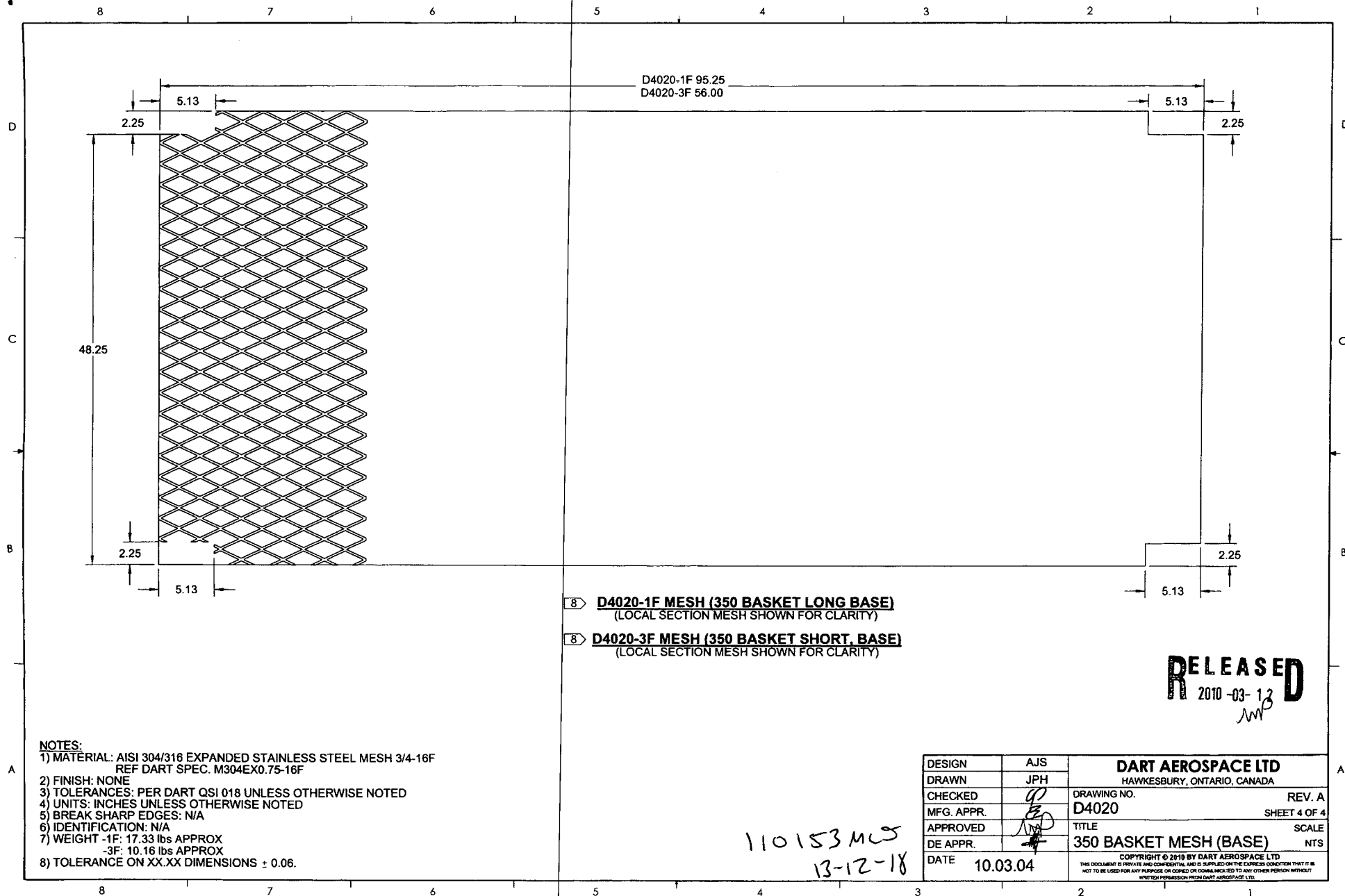
### D3913-15 WIDE HANDLE PLATE

#### NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2013-08-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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2010-03-13  
*[Signature]*